

Work Order ID 124345

September-11-14 12:02:53 PM

124345

Page 1

Item ID: D3849-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Wearplate Assy, Std/Float Gear
 Start Date: 9/05/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 9/10/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-09-17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3849	D								

110

0.00

110

Large Fab

Large Fab

Memo

0.00

1- On D3901-1 bar, fill cut outs with hardcoat welding rod as per dwg D3849

2059 B Hardcoat Welding Rod

BATCH#: M131090

2- Weld D3901-1 bar to wearplate as per dwg D3849

304 S.S. Welding Rod

BATCH #: M128077

3- Transfer drill holes as per dwg

4- Cut excess bar material if necessary

x4 15-04-22 MAL

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Quality Control

Memo

0.00

4 15-5-7

DAS
50

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ </td> <td style="width: 33%;"> Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width: 33%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 33%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4	15-5-7		DAS 50 9-89
140 *140* Small Fab Small Fab	QC5- Inspect part completeness to step on W/O Memo 1- Apply a layer of rockguard as per dwg BATCH: 132113	0.00 0.00				4			DAS 41 9-89
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(4)			DAS 30 9-89

MAY 08 2015

DQA: _____ Date: _____



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00							
160									
Packaging	Memo	0.00				x4	q	21	15/05/14
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MAY 12 2015

MAY 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

September-11-14 12:02:52 PM

Page 1

Work Order ID: 124345

124345

Parent Item: D3849-041

D3849-041

Parent Item Name: Fwd Wearplate Assy, Std/Float Gear

Start Date: 9/05/14

Required Date: 9/10/14

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP RevA: New issue DD verified by:EC

IPP Rev:B

12.09.11 AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3849-1		Manufactured	No			110	Each	19.0000	1	4			

D3849-1

Plate

**

B127091 x4

Location

Loc Qty

Loc Code

WA001

13

119045

13

WA002

6

123157

6

D3901-1

Manufactured

No

110

Each

28.0000

1

4

D3901-1

Bar

**

B129813 x4

Location

Loc Qty

Loc Code

WA001

28

118916

12

122967

16

x4

15-04-22 MAL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

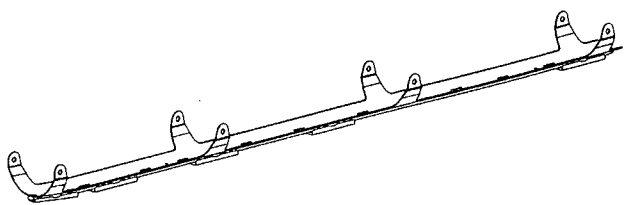
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Transport									
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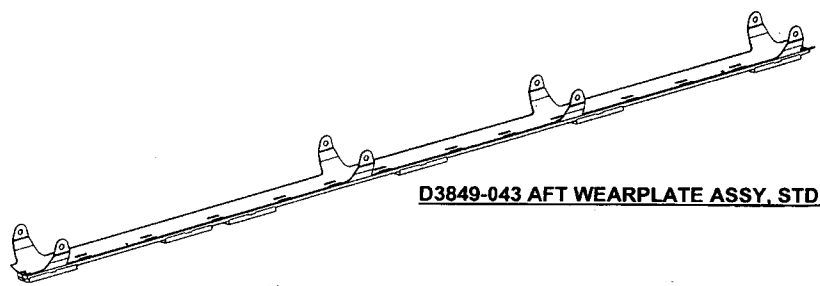
FAULT CATEGORY

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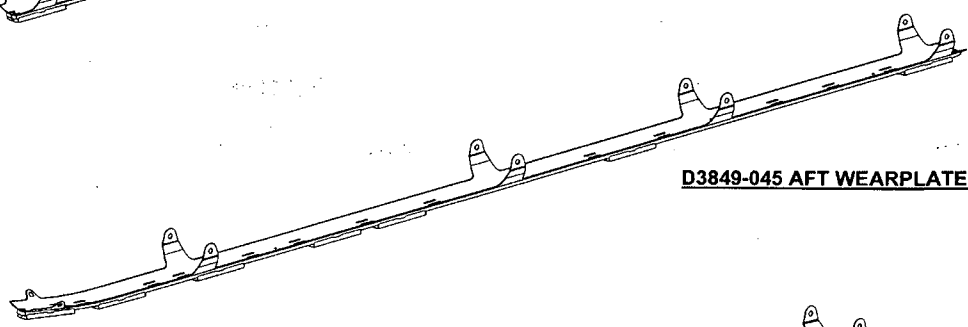
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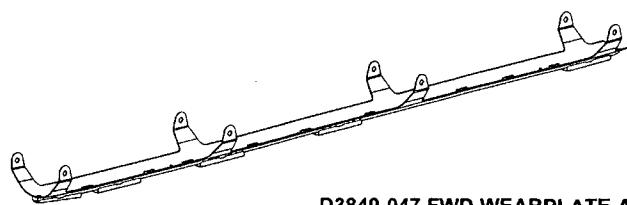
D3849-041 FWD WEARPLATE ASSY, STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR

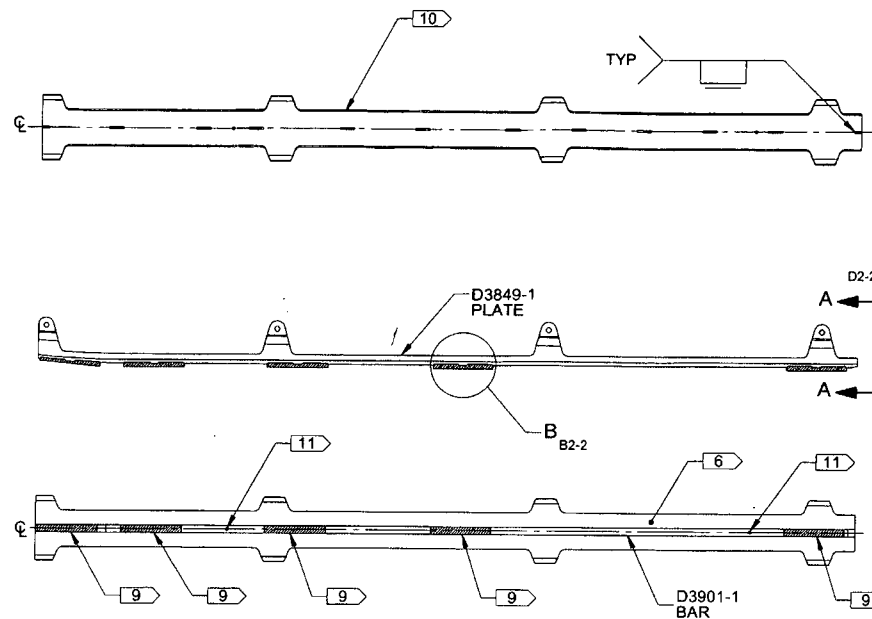
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1			1	D3901-1	BAR
16		2			D3901-3	BAR
17			2		D3901-5	BAR
21	A/R	A/R	A/R	A/R	2059B	HARDCOAT
22	A/R	A/R	A/R	A/R	4714	PLUS ONE ROCKGUARD

NOT COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

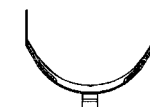
NO 124345 MLS
14-09-17

RELEASED
2012-09-04

D	REVISED FLAT PATTERN - CHANGED SLOT LOCATIONS, TO MATCH D3901-1/3/5 BARS (ZN B6-6, B3-6, B6-7, C2-7, B6-8, B2-8, B7-9, B2-9)	DC	12.08.23
C	REVISED FLAT PATTERN - CHANGE SLOT LOCATIONS, ADDED DOUBLE SLOTS AND D3901-3/5 BARS ON -043/-045. UPDATED DETAIL VIEWS. CHANGED WELD DETAILS (ZN B2-2). REMOVED D3849-1/3/5/7 GASKETS, ADD ROCKGUARD COATING, REMOVE FINISH	DC	12.08.21
B	REVISED FLAT PATTERN 0.0375 WAS SLOT HOLE ON D3849-1/3/5/7 (ZN A4-5, B4-7, B4-8, C2-10, B2-10). ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7/7F (ZN C4-9, A4-9); ADD SECTION K-K (ZN C5-10); 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10); ADD 0.25 & 0.88 (ZN D4-10, D3-10); ADD 0.88 & 0.44 (ZN C3-10 & B3-10); ADD FLAG NOTE (ZN A8-2, C6-2, C3-2, A8-3, C6-3, A8-4, C6-4, C2-4); 66 87 WAS 67.36 (ZN B4-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	JS	DRAWING NO.	REV. D
MFG. APPR.	JS	D3849	SHEET 1 OF 10
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	WEARPLATE ASSY	NTS
DATE	12.08.23	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

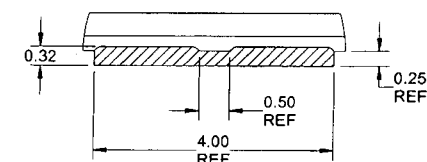


D3849-041 FWD WEARPLATE ASSY, STD/FLOAT GEAR



SECTION A-A

C3-2



DETAIL B

C5-2

RELEASED
2012-09-04

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-041 = 4.58 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON LATERAL SURFACES
- 10) COAT-ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4744, 0.020-0.040 THICK
- 11) TRANSFER DRILL ϕ 0.188 HOLES FROM D3849-1 PLATE TO D3901-1 BAR

Handwritten: 4715A

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	JS	DRAWING NO. D3849	REV. D
MFG. APPR.	JS	SHEET 2 OF 10	
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	WEARPLATE ASSY	NTS
DATE	12.08.23	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	